

Work Order ID 64498

Tuesday, December 07, 2010 8:51:44 AM



Page 1

Item ID:	D4114-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Door Doubler, LH				Stop	
Start Date:	12/7/2010	Start Qty:	4.00			
Required Date:	12/20/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:		Date:	10-12-7	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4114	A								
100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet									
304.063									
	Memo								
	1-Cut as per Dwg								
	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110		0.00							
QC		0.00							
Quality Control									

B10-12-16

4

B10-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64498

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Page 2

Item ID: D4114-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Doubler, LH

Start Date: 12/7/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



8/10/12/16

QC

Memo

0.00

Quality Control

(+4)

130

0.00



0.00

Small Fab

Memo

Small Fab

1- C'sink holes as per dwg

E 5/10/12/17 (+4)

140

QC5- Inspect part completeness to step on W/O

0.00



8/10/12/17

QC

Memo

0.00

Quality Control

(+4)

-1

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D4114-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Doubler, LH

Start Date: 12/7/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/20/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 130

0.00



Packaging

Memo

0.00

Packaging

10/12/17 SP

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/20 *[Signature]*
MF
10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, December 07, 2010 8:51:48 AM

Page 1

Work Order ID: 64498

Parent Item: D4114-1

Parent Item Name: Door Doubler, LH

Start Date: 12/7/2010

Required Date: 12/20/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	124.0000	0.25	1.052632			



304/316 Sheet .063



1210-12-16

Location

Loc Qty

Loc Code

MAT

124

111323

0

115953

124

115953

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64498
Description: Door Double End LH.		Part Number: D 4114-1
Inspection Dwg: D 4114-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

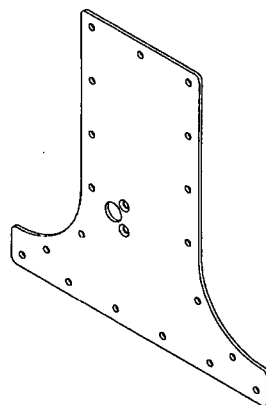
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.128	X		BY 02	
Ø .375	+ .006 - .001	.375	✓		V	
.25	± .030	.251	✓		V	
2.250	± .010	2.256	✓		V	
1.125	± .010	1.125	✓		V	
2.75	± .030	2.750	✓		V	
.254	± .010	.252	✓		V	
.508	± .010	.508	✓		V	
6.00	± .030	6.011	✓		V	
.75	± .030	.754	✓		V	
.75	± .030	.751	✓		V	
5.50	± .030	5.502	✓		V	
1.10	± .030	1.098	✓		V	
6.00	± .030	6.008	✓		V	
.64	± .030	.645	✓		V	
1.38	± .030	1.382	✓		V	
2.20	± .030	2.205	✓		V	
.75	± .030	.746	✓		V	
3.30	± .030	3.298	✓		V	
1.10	± .030	1.098	✓		V	
.063	± .010	.058	✓		V	

Measured by:	RB
Date:	10-12-16

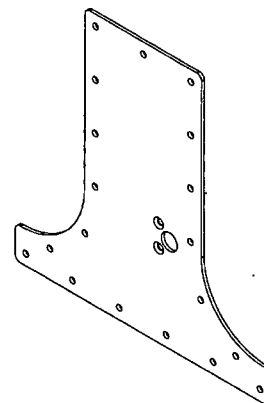
Audited by:	S
Date:	10/12/16

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4114-1 DOOR DOUBLER, LH



D4114-2 DOOR DOUBLER, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64498

DT 10-12-7

RELEASED
2010-09-23

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4114 TITLE DOOR DOUBLER SCALE NTS	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. A SHEET 1 OF 2	
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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